



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-4-2

Job Sheet 191802



Part No: C45-4-2

Job Qty: 8 pcs

Part Name: Trunnion, Load Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/8/19

Job Tracking No:

Due Date: 3/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-4-4KA REV.20 IPP REV:A 18.02.09 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	SL-154 - 1	8 pcs	3/29/19	3/29/19	0.00	1.00	SL-154 - 1		JB 19.03.20
130	QC 2	8 pcs	3/29/19	3/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		JB 19.03.20
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S164471

Part: C45-4-2

Job No: 191802

Serial No/Batch: S164471

Revision: 20

Inspector:

Exp Date:

Instructions:

Date: 03/20/19

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DAS
62
9-89

DAS
62
9-89

3/8/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

160 QC 8	8 pcs	3/29/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
170 Outsource	8 pcs	3/29/19		MEI001-VC	10 03/22/2019 4L
180 Packaging 2-1 - Receive - B4B 8 pcs 16	8 pcs	3/29/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	

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190 QC 6	8 pcs	3/29/19	0.00 0.00	Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
200 Packaging 3-2 - Stock - B4B	8 pcs	3/29/19	0.00 0.00	QC 6 - 61	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
210 QC 21 - SA	8 pcs	3/29/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-39
				QC 21 - SA - 53	

APR 09 2019

Part Op 120 - (MORI SL-154 LATHE)1-Machine as per folio FB841 FOLIO REV: AA DWG REV: 20 2-
 Descriptions: Deburr
 130 - QC2- Inspect parts off machine FAI/FAIB)
 160 - (QC8- Inspect parts - second check)
 170 - 1-Issue P/O to Metcore ; P/O _____ RC 42-46 2-Bead blast 3- Certificate of Conformity is required
 180 - (Receive & Inspect for Damage & Mat'l Certs)
 190 - (QC6- All purchased or subcontracted products)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

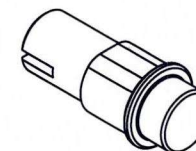
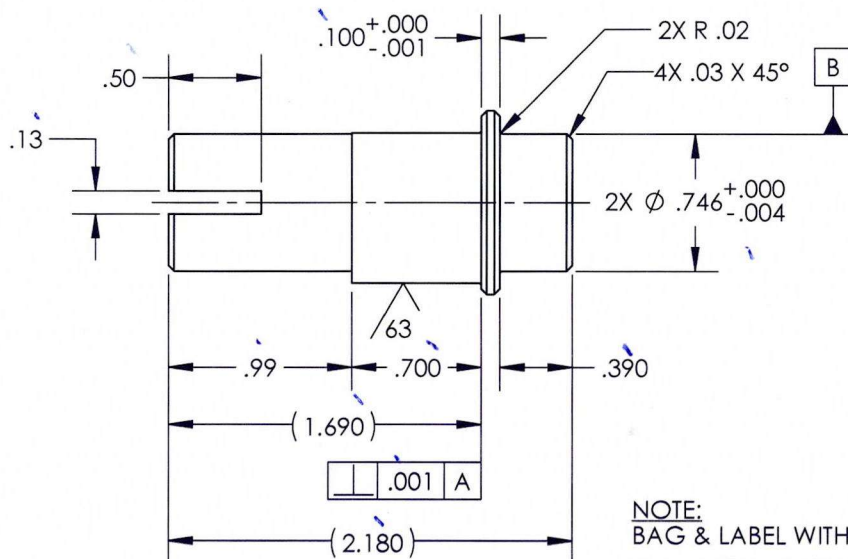
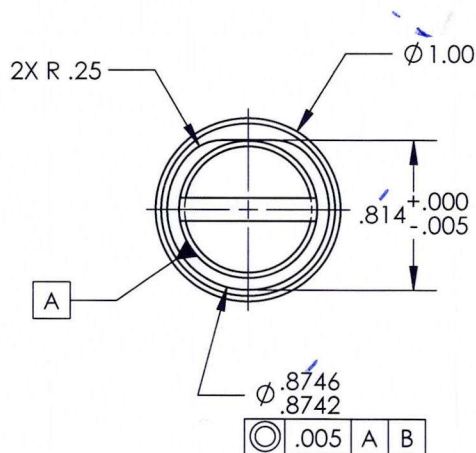
Part / Item	Component Name	Quantity	Operation	Container
M4140H-R1.000	4140 round bar 1.00	1.6000 ft (.2 ea)	120-SL-154 - 1	S070822

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-SL-154 - 1	M4140H-R1.000	2	7	0
Part Specifications				
Specifications could not be found.				

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191802



NOTE:
BAG & LABEL WITH BATCH NUMBER.

C45-4-2

TRUNNION

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		AS DRAWN BY CANAM.	2/14/2005		
16		INCREASED CENTER DIAMETER AND ADDED FLAT.	9/12/2012	JAG	
18	14-0126	C45-4-2 ADDED BAG & LABEL NOTE.	8/13/2014	DPD	RW
19	15-0099	C45-4-2 CH'D HEAT TREAT WAS RC 34-37 IS RC 42-46.	5/8/2015	DPD	JAG
20	17-0133	C45-4-2 DELETED DIM 2X R.03.	6/5/2017	RJC	JAG

DART AEROSPACE	
TITLE C45 LOAD BEAM ASSEMBLIES	
DWG NO. C45-4-4A / C45-4-4KA	REV 20
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT HRC 42-46	DIMENSIONS ARE IN INCHES
FINISH SEE SHEET 1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	X ± .1 SURFACES = 125/
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: DD 06/05/2017	.015 x 45° OR .015R
OPPS APPR: AA 06/06/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 06/14/2017	AFTER PLATING
APPROVED: JAG 06/15/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
SCALE 1:1	DATE 9/12/2012
	SHEET 3 OF 6



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042955



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Cloutier, Danielle

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042955
PO Date: 3/22/19
Due Date: 4/5/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191802	C45-4-2	Trunnion, Load Beam 1--Issue P/O to Metcore ; P/O _____ RC 42-46 2-Bead blast 3- Certificate of Conformity is required Material : 4140 Round Bar 1.00	Firmed -		4/5/19	16 pcs	0 pcs	16 pcs	\$19.375/pcs	\$310.00
Grand Total:											\$310.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/25/19 4:30 PM dart.Lussier.Patrick

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL	EXPÉDITEUR	BON D'EXPÉDITION
Order	Shipper ID	Shipper
335146	1	136079

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT	BON DE LIVRAISON DU CLIENT	TYPE DE MATÉRIEL	DATE DE LA COMMANDE	TRANSPORTEUR
Customer PO	Customer Shipper No.	Material Type	Order Date	Carrier
42955 ✓		4140	2019/3/22	client

QUANTITÉ	No. PIÈCE	NOM DE LA PIÈCE	DESCRIPTION DE LA PIÈCE	POIDS
Quantity	Part No.	Part Name	Part Description	Weight
✓ 16	c45-4-2 ✓	(16) C45-4-2		5,
		JOB 191802		

1 BOITE DE CARTON

TYPE DE CONTENEUR	# DE CONTENEURS	COMMENTAIRES CONTENEUR
Container Type	# Of Containers	Container Comments
BOITE DE CARTON	1	

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 16

POIDS EXPÉDIÉ / Weight Shipped : 5,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

QUANTITÉ EXPÉDIÉE Quantity Shipped: 16

POIDS EXPÉDIÉ / Weight Shipped : 5,00

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
335146	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
42955	N/A	4140		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	42 - 46 HRC	16 (907)	44 - 46 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
16	5	c45-4-2 (16) C45-4-2 JOB 191802 1 BOITE DE CARTON		

COMMENTAIRES / comments

SALT HARDEN 1550F 50 MINS
TEMPER 725F 3:00 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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METCOR INC.

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Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
335146	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

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APPROUVÉ par / Approved by:

Lucie Desmarais
QA Technician



DATE: 2019-04-04

METCOR INC.

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Tél.: 450-473-1884

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Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
335146	1

CLIENT / customer 215

DART AEROSPACE

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ON K8A 1K7

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DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
42955	N/A	4140		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	42 - 46 HRC	16 (907)	44 - 46 HRC

DAS
68
9-89

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
16	5	C45-4-2 (16) C45-4-2 JOB 191802 1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2019-04-03

Pierre Piché
Chief Inspector

METCOR
6

APPROUVÉ